

Date: Tuesday, 07/04/2009 10:21:14 AM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : FWD TUBE ASSEMBLY
<b>Job Number</b> : 46979	
<b>Estimate Number</b> : 10467	
<b>P.O. Number</b> :	<b>Part Number</b> : D3391021
<b>This Issue</b> : 07/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3391 REV H
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : H
<b>Previous Run</b> : 46646	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 27/04/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>JD 09 04 07</u>	
<b>Comment</b> :	
Est. A 05.09.13 New issue KJ/JLM	
Est. B 06.02.10 Dwg rev.D ecn 773 EC	
Est. C 06.05.02 Added inspections EC	
est D 07.03.13 rev F dwg EC	
est E 07.11.07 revG dwg ecn1053P EC verified by: DD	
Est Rev:f ECN 1056 07-11-12 DD verified by: EC	
Est Rev:G 08-09-08 new process (ecn 08-510) DD verified by:EC	
Est Rev:H 08-09-10 revH as per dwg DD verified by:EC	
Est Rev J 09.02.02 added hardware EC verified by: DD	

SCRAP

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D6013047	Skidtube Material
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SKIDTUBE MAT'L

Pick:

Qty	Part Number	Description
1	D6013-047	Extrusion

Batch

23935

RT 09-04-13

2.0	SKIDTUBES 1	SKIDTUBESS RESOURCE 1
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**Comment:** LANDING GEAR RESOURCE 1

Cut extrusion to 46.52 +0.010 -0.020

RT 09-04-14

3.0	BENDING	BENDING MACHINE - SKIDTUBES
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**Comment:** Nc bender

Bend as per Dwg D3391 Using Bend Prog 3391021

RT 09-04-14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3391-021 PAR #: N/A Fault Category: Prod / Skid tube NCR: Yes No DQA: D Date: 05/06/04  
 Resolution: D412-742-043 SCRAP Disposition: SCRAP QA: N/C Closed: D Date: 01/06/04

NCR: <u>46979</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-04-14	3.0	Tube under bent by .500"; tried to bend within tolerance. over bent by .188" over tolerance. machine malfunction scrap + replace <u>B23935</u> P.C. process.	<u>BSU112</u>	Scrap & replace x1 B23935 <u>destroyed.</u>	<u>IT</u> <u>090414</u>	<u>BSU114</u>	<u>BSU112</u>	<u>050413</u>

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FWD TUBE ASSEMBLY

Job Number: 46979

Part Number: D3391021

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

4.0

QC5

INSPECT WORK TO CURRENT STEP



$h = 6.875"$   
 $\angle = 13.3^\circ$



Comment: INSPECT WORK TO CURRENT STEP

SA 09/04/14

5.0

HAAS1

HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine as per Folio FA590 Rev. F & Dwg D3391 Rev. 14  
Identify as D3391-1

2-Deburr

M.A 09/04/26

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

M.A 09/04/26

7.0

MILLING CONV.

CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Drill X1 Aft cap as per Dwg D3391 .1875" dia

SA 09/04/27

8.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SA 09/04/27

9.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 09/04/28

10.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Drill float bag holes as per Dwg D3391 using DT8798(Do not open tow cap holes to finish size)  
(ONLY DRILL HOLES MARKED "A")

2-Drill Remaining two holes for tow cap using DT 8819 Locating off of .1875" holes drilled in previous step

3-Open tow cap holes to .208" as per Dwg D3391

4-Open Tow Ring hole to .640" as per Dwg D3391

5- open float bag holes 0.328" and counter sink as per dwg D3391

M 9-429

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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Drawing Name: FWD TUBE ASSEMBLY

Job Number: 46979

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Deburr & Scribe Batch number Inside aft end.

7-Transfer drill D3391-021 with D3391-023

M 9-4-29

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 07/04/09 (40)

12.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AWM 9-4-30

(1)

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D M 9-4-30

14.0

D36704200

SPACER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

SPACER

batch:

B 46106

(4)

M 9-4-30

15.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-instal spacers as per dwg D3391

A/R Magnabond 6398 batch:

M 111299

M 9-4-30

exp. date: 10-8-1

cure time 12hrs. as per QSI015

2- grind crossbolt flush

3-back drill crossbolt if necessary

M 9-5-4

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 07/05/04 (40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Job Number: 46979

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

17.0

POWDER COATING

POWDER COATING



m/09996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME:

12:40

OVEN TEMPERATURE:

320°

FINISH TIME:

1:10

FL 09/05/04 (1)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-05-5 (1)

19.0

D3401041

Tow Cap Assembly



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Tow Cap Assembly

20.0

D356413

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearshoe

21.0

D356613

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Gasket

22.0

D36721

Phenolic Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)  
Phenolic Washer

23.0

AN3C4A

BOLT



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
BOLT

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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Job Number: 46979

Part Number: D3391021

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN960C10L

washer



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
washer

25.0

ALS41032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)  
INSERT

26.0

ALS41032225

Insert



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)  
INSERT

27.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1  
Identify and Stock  
Location: \_\_\_\_\_

*pull.  
47065  
becomes  
scrap on  
that w/o.*

28.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: SKIDTUBESS RESOURCE 1  
\*\*\*\* install D3591-1 spacer as per DSI9364 \*\*\*\*

29.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



*MF  
09-06-03*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> <u>H679</u>
<b>Description:</b> Float Skidtube (412)		<b>Part Number:</b> <b>D3391-1</b>
<b>Inspection Dwg:</b> D3391	<b>Rev:</b> G	<b>Page 1 of 1</b>

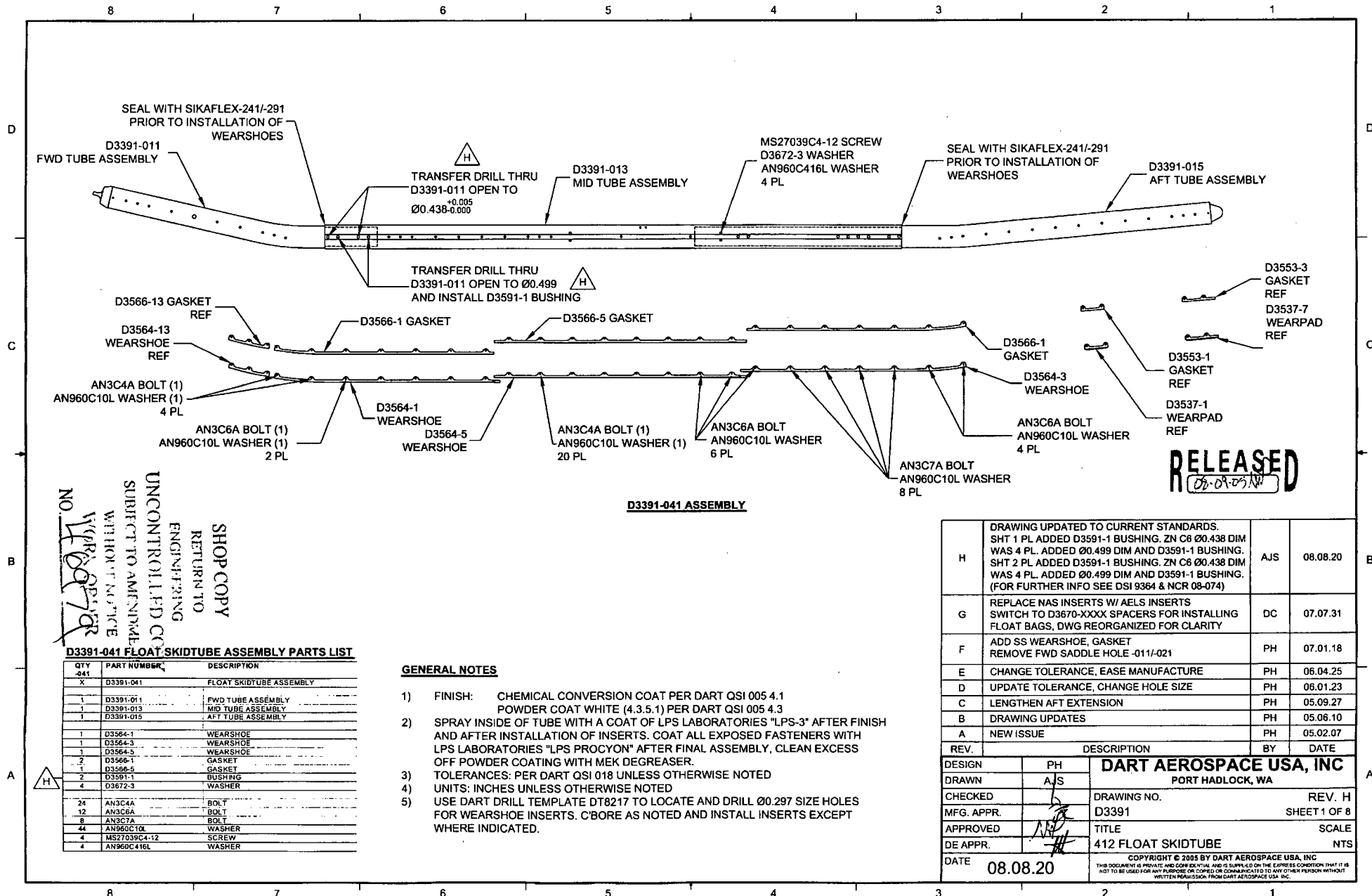
### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.687	+0.010/-0.000	0.692	✓			
3.590	+0.025/-0.010	3.588	✓			
3.300	+0.040/-0.000	3.320	✓			
1.429	+0.040/-0.060	1.420	✓			
4.250	+/-0.010	4.250	✓			
4.250	+/-0.010	4.255	✓			

<b>Measured by:</b> <u>B.A</u>	<b>Audited by:</b> <u>SA</u>	<b>Prototype Approval:</b>	N/A
<b>Date:</b> <u>09/04/26</u>	<b>Date:</b> <u>09/04/27</u>	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	06.04.27	New Issue P/O D3391-011/-021	KJ/JLM	
B	06.06.19	Tolerances revised per D3391 Rev. E	KJ/JLM	
C	07.03.21	Dimensions removed per Dwg rev. F	KJ/JLM	
D	07.11.23	Dwg Rev. updated	KJ/EC/DD	<u>[Signature]</u>



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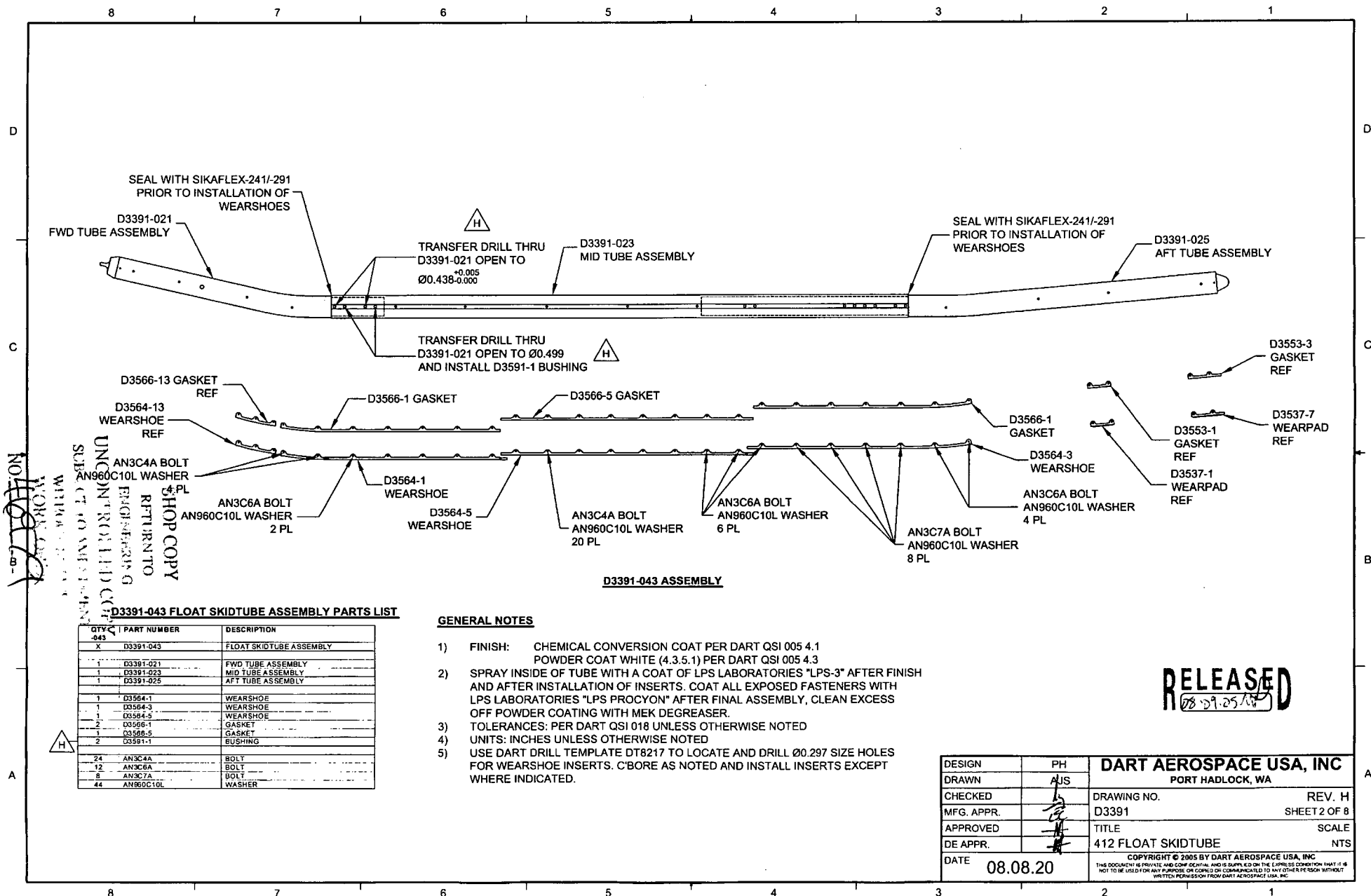
# **D3391-041 FLOAT SKIDTUBE ASSEMBLY PARTS LIST**

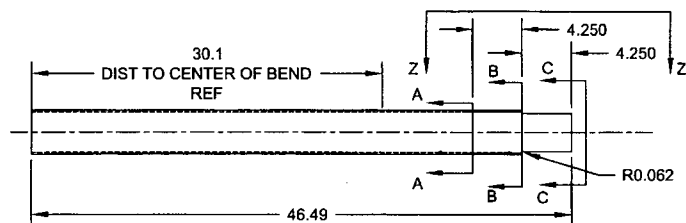
QTY	PART NUMBER	DESCRIPTION
X	D3391-041	Float Skid Tube Assembly
1	D3391-011	FWD TUBE ASSEMBLY
1	D3391-013	MID TUBE ASSEMBLY
1	D3391-015	AFT TUBE ASSEMBLY
1	D3564-1	WEARSHOE
1	D3564-3	WEARSHOE
1	D3564-5	WEARSHOE
2	D3566-1	GASKET
1	D3566-5	GASKET
2	D3591-1	BUSHING
4	D3672-3	WASHER
20	AN3C4A	BOLT
12	AN3C6A	BOLT
6	AN3C7A	BOLT
44	AN960C10L	WASHER
4	MS27039C4-12	SCREW
4	AN960C416L	WASHER

## **GENERAL NOTES**

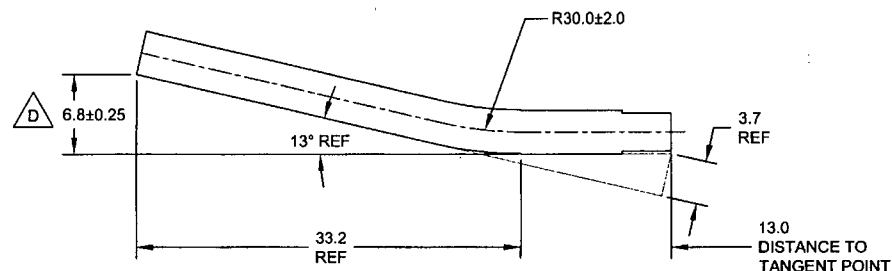
- 1) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH  
AND AFTER INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH  
LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS  
OFF POWDER COATING WITH MEK DEGREASER.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) USE DART DRILL TEMPLATE DT8217 TO LOCATE AND DRILL  $\varnothing 0.297$  SIZE HOLES  
FOR WEARSHOE INSERTS. C'BORE AS NOTED AND INSTALL INSERTS EXCEPT  
WHERE INDICATED.

H	DRAWING UPDATED TO CURRENT STANDARDS. SHT 1 PL ADDED D3591-1 BUSHING. ZN C6 $\varnothing 0.438$ DIM WAS 4 PL. ADDED $\varnothing 0.499$ DIM AND D3591-1 BUSHING. SHT 2 PL ADDED D3591-1 BUSHING. ZN C6 $\varnothing 0.438$ DIM WAS 4 PL. ADDED $\varnothing 0.499$ DIM AND D3591-1 BUSHING. (FOR FURTHER INFO SEE DSI 9364 & NCR 08-074)	AJS	08.08.20
G	REPLACE NAS INSERTS W/ AELS INSERTS SWITCH TO D3670-XXXX SPACERS FOR INSTALLING FLOAT BAGS, DWG REORGANIZED FOR CLARITY	DC	07.07.31
F	ADD SS WEARSHOE, GASKET REMOVE FWD SADDLE HOLE -011/-021	PH	07.01.18
E	CHANGE TOLERANCE, EASE MANUFACTURE	PH	06.04.25
D	UPDATE TOLERANCE, CHANGE HOLE SIZE	PH	06.01.23
C	LENGTHEN AFT EXTENSION	PH	05.09.27
B	DRAWING UPDATES	PH	05.06.10
A	NEW ISSUE	PH	05.02.07
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 1 OF 8
APPROVED		TITLE	SCALE
DE APPR.		412 FLOAT SKIDTUBE	NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

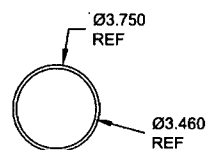




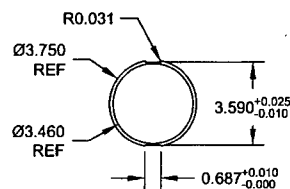
**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)



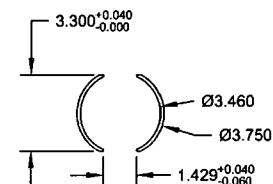
**D3391-011/-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



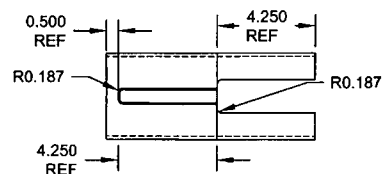
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X




**SECTION C-C**  
SCALE 2X

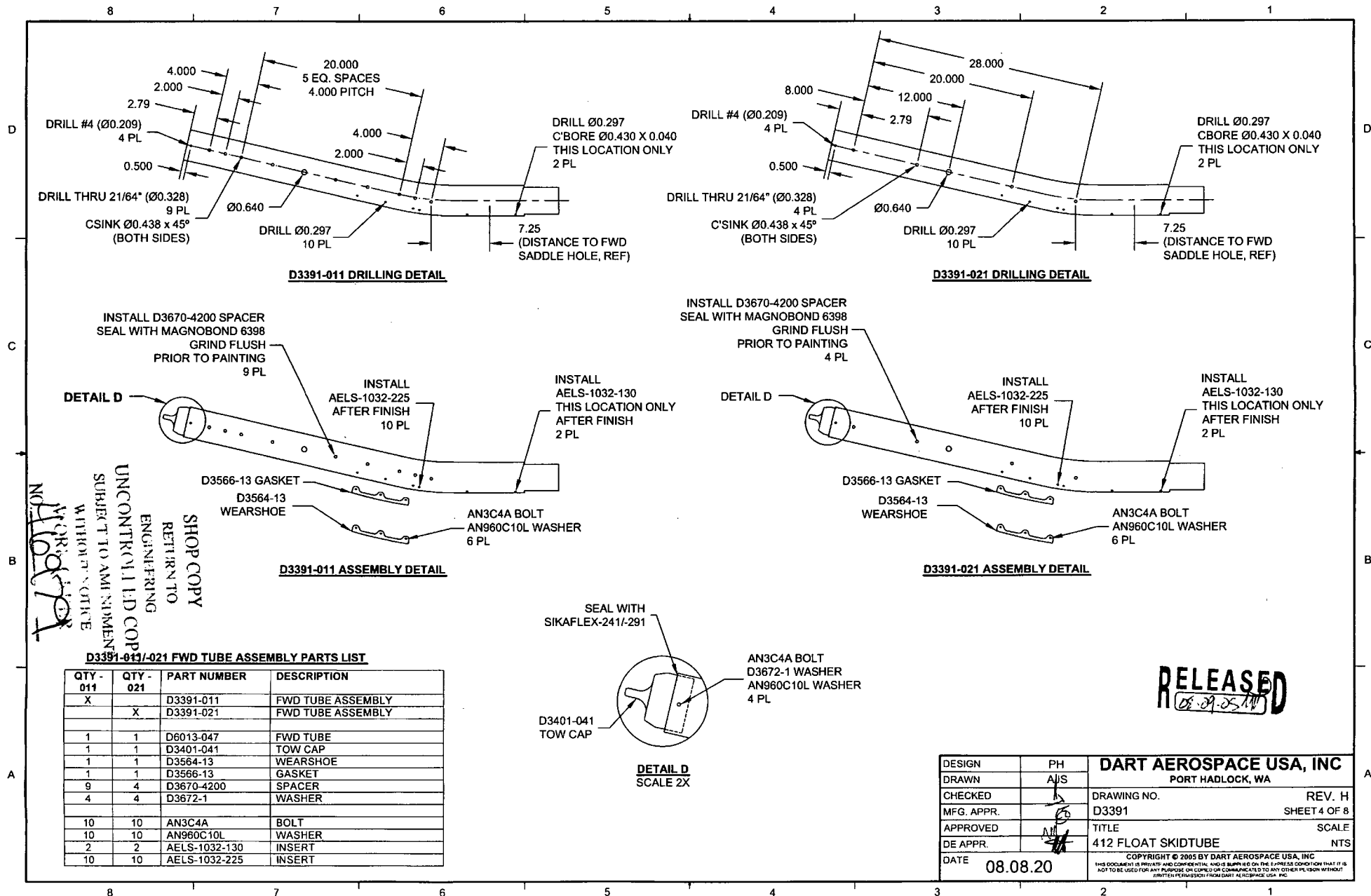


**VIEW Z-Z**  
SCALE 2X

**RELEASED**  
08-05-11

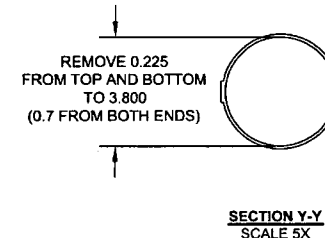
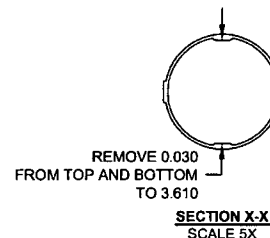
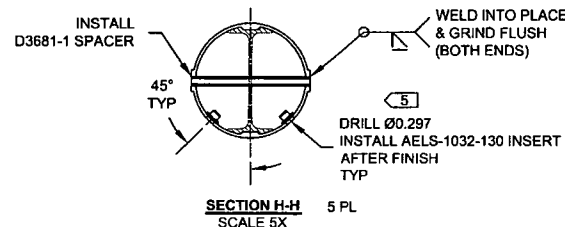
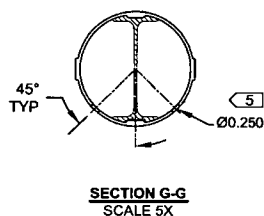
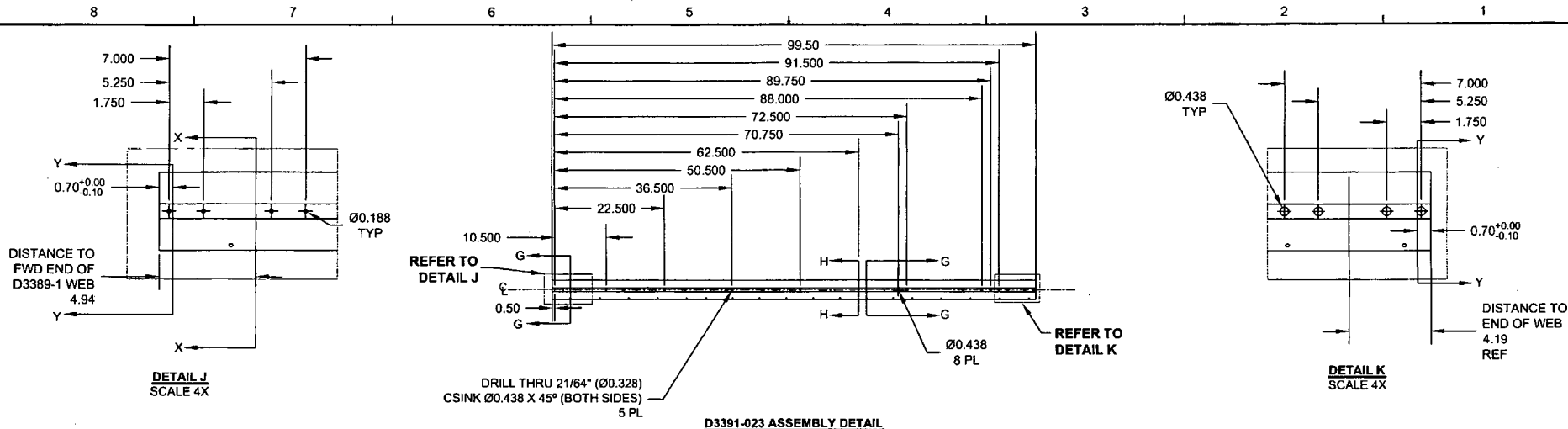
DESIGN	PH	<b>DART AEROSPACE USA, INC</b>	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D3391	SHEET 3 OF 8
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# **D3391-023 MID TUBE ASSEMBLY PARTS LIST**

QTY - 023	PART NUMBER	DESCRIPTION
X	D3391-023	MID TUBE ASSEMBLY
1	D2500-1-100	EXTRUSION
1	D3389-1	WEB
5	D3681-1	SPACER
20	AELS-1032-130	INSERT

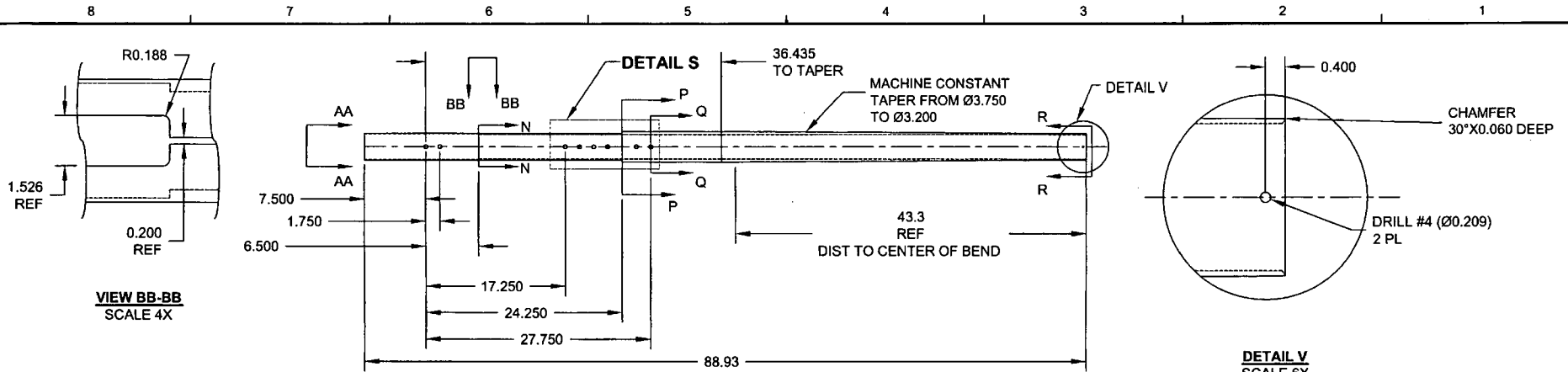
**RELEASED**  
08-27-05-14

DESIGN	PH	<b>DART AEROSPACE USA, INC</b>
DRAWN	AS	PORT HADLOCK, WA
CHECKED	5	DRAWING NO. REV. H
MFG. APPR.	5	D3391 SHEET 6 OF 8
APPROVED	5	TITLE SCALE
DE APPR.	5	412 FLOAT SKIDTUBE NTS
DATE	08.08.20	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC

## **D3391-023 MID TUBE ASSEMBLY**

1. MATERIAL: MAKE FROM D2500-1-100 EXTRUSION
2. INSTALL D3389-1 WEB TO OUTER TUBE USING SIKAFLEX-241/291 PER QSI 015
3. WELDING: PER DART QSI 004

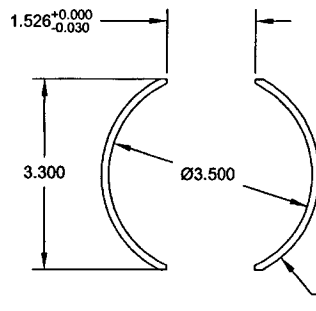
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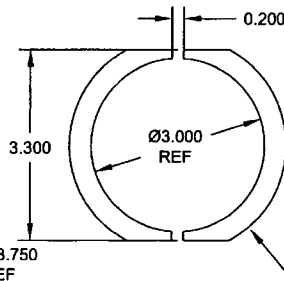
**VIEW BB-BB**  
SCALE 4X

**D3391-3 AFT DRILLING AND CUTTING DETAIL**  
(MAKE FROM D6014-090 SKIDTUBE MATERIAL)

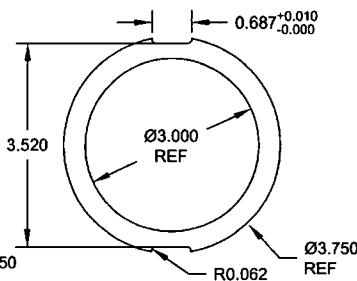
**DETAIL V**  
SCALE 6X



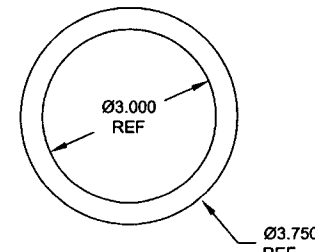
**SECTION AA-AA**  
SCALE 6X



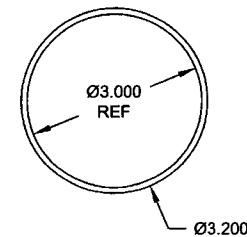
**SECTION N-N**  
SCALE 6X



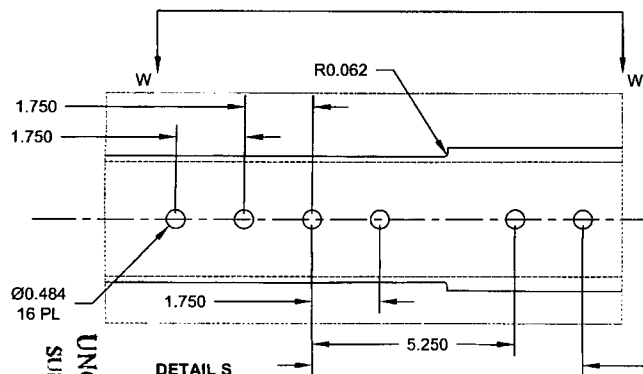
**SECTION P-P**  
SCALE 6X



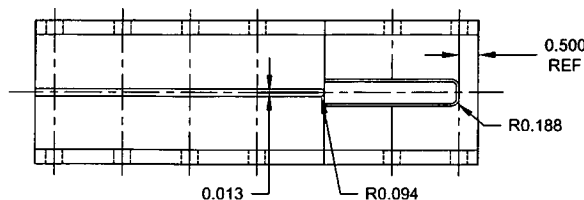
**SECTION Q-Q**  
SCALE 6X



**SECTION R-R**  
SCALE 6X



**DETAIL S**  
SCALE 4X

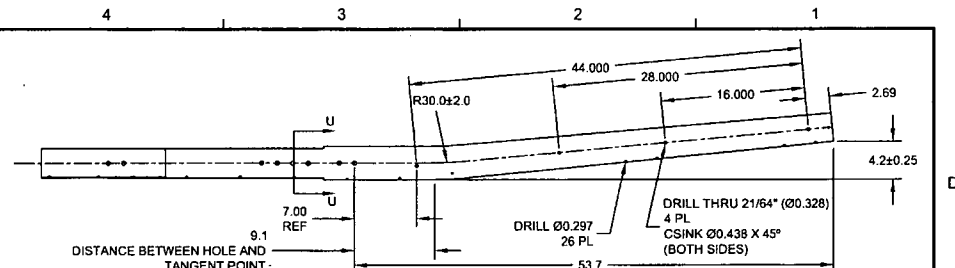


**VIEW W-W**  
SCALE 4X

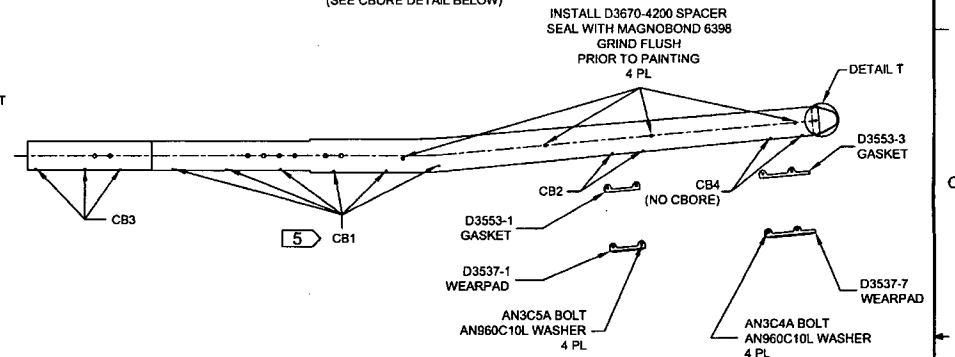
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28 APR 2005

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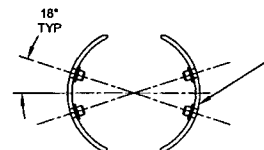


**D3391-025 BENDING AND DRILLING DETAIL**  
(SEE CBORE DETAIL BELOW)

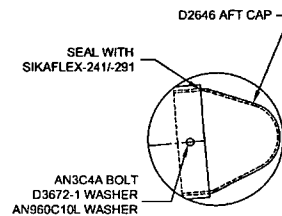


**D3391-025 ASSEMBLY AND CBORE DETAIL**  
(SEE TABLE)

QTY - 015	QTY - 025	PART NUMBER	DESCRIPTION
X		D3391-015	AFT TUBE ASSEMBLY
	X	D3391-025	AFT TUBE ASSEMBLY
1	1	D6014-090	AFT TUBE
1	1	D2846	AFT CAP
1	1	D3537-1	WEARPAD
1	1	D3537-7	WEARPAD
1	1	D3563-1	GASKET
1	1	D3563-3	GASKET
14	4	D3670-4200	SPACER
2	2	D3672-1	WASHER
14	14	AELS-1032-130	INSERT
12	12	AELS-1032-225	INSERT
4		ALS4-428-165	INSERT
6	6	AN3C4A	BOLT
4	4	AN3C5A	BOLT
10	10	AN960C10L	WASHER



**SECTION CC-CC**  
**SCALE 3X**



**DETAIL T**  
**SCALE 4X**

RELEASED  
08-09-05

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

HOLES MARKED	QTY D3391-015	QTY D3391-025	CBORE	P/N
CB1	12	12	Ø0.430 X 0.170	AELS-1032-225
CB2	4	4	Ø0.430 X 0.170	AELS-1032-130
CB3	6	6	Ø0.430 X 0.040	AELS-1032-130
CB4	4	4	NONE	AELS-1032-130

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